

Date: Monday, 16/03/2009 9:15:18 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BK117 SKIDTUBE ASSEMBLY
Job Number : 46498A	
Estimate Number : 12898	
P.O. Number :	Part Number : D117762041
This Issue : 16/03/2009 S.O. No. :	Drawing Number : D3582 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : A
Previous Run : 46496A	Material :
Written By :	Due Date : 31/03/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 09.03.16</u>	
Comment : Est Rev:A 07.06.11 New Issue EC Est Rev:B 08-02-22 change to revA as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D117-762-041 CHG001

N/A *[Signature]*

2.0	D2962150	3.540 Outer Tube, Extrud
-----	----------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
	<i>[Redacted]</i>	Extrusion	<i>B28672</i>

DP 9-3-16 *(i)*

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678.

3- open holes to 5/16"

MP 09-03-16 *(1)*

4.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------



Comment: BENDING MACHINE

Bend tube as per program D3582 on CNC Bender and Dwg D3582. Use 5/16" locator pin on buggy "A".

MP 09-03-16 *(1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185

2-Cut Aft end using DT8185

3-Deburr ends

4-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE***

5-Locate DT 8973 & Drill Ground wire hole on top of Tube.

6-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill.

7-Drill pilot holes for wearplates using DT8974

8-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.

9- open ground wear holes to 0.391" as per section B-B

10-Open Aft Cap holes using .209" drill.

11-Deburr holes.

9-3-16

Paul 09-03-17

6.0

D2964

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

214101 BE 09/04/07

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld fwd cap D2964 per dwg D3582 and QSI 004

A/R AL ROD

Batch:

m110676

BE 09/04/07

2-Grind flush

9-4-8

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Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

Handwritten: 09-04-08 ①

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 09-04-08 ①

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: ① M 9-4-8

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: ① M 9-4-8

12.0

D2971

Cross Bolt Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cross Bolt Spacer

batch *044445 ① M 9-4-9*

13.0

D2973

Cross Bolt Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cross Bolt Spacer

Batch: *014636 ② M 9-4-9*

14.0

D36621

Crossbolt Spacer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

SPACER

batch *039525 ③ M 9-4-9*

15.0

D36623

Crossbolt Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SPACER

batch *044456 ① M 9-4-9*

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Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

D35841

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEB

646540 D H 9-4-8

17.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open X-Bolt holes to .750"(4Places) as per Dwg D3582, section B-B

2-Counter Sink X-BOLT holes as per Dwg D3582

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3582 & QSI 015

A/R 241 Sike Flex

Batch: 111081

Exp Date: 10-1-7

5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B.

A/R AL ROD

Batch: M110676 BB

9-4-13

6-Grind welds flush

AWM 9-4-14

Tools: E

18.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/04/14 (X)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/14 (X)

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Pressure wash M110934

09/04/14 (X)

START TIME:

3:40

OVEN TEMPERATURE:

320°

FINISH TIME:

4:10

16 09-04-23 (1)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-27

(XV)

22.0

ALS41032130

Insert



Comment: Qty.: 36.0000 Each(s)/Unit Total : 36.0000 Each(s)

Insert

Batch:

M1108606

X JV

23.0

ALS4428165

Inserts



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inserts

batch

M116989

***same as ALS7-428-165 QSI 0017 ***

JV

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Wearplate & Ground Wire inserts as per Dwg D3582.

JV

09-04-27

(XV)

25.0

D2965

Cap, 105 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

1347235

JV

26.0

D35083

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch:

1342250

JV

27.0

D35089

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch:

1336417

JV

09-04-27

(XV)

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D350811

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Batch: 1346880

WEARPLATE

ell

29.0

D350813

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: 1342252

ell

30.0

D35583

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1345661

ell

31.0

D35589

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1340361

ell

32.0

D355811

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1340399

ell

33.0

D355813

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1340400

ell

34.0

AN3C4A

BOLT



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

BOLT

Batch: 1111193

ell

09-04-23

ell

W/O:		WORK ORDER CHANGES					
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Job Number: 46498A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN3C5A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: 1111424

ju

36.0

AN44A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch 11108138

ju

37.0

AN960C10L

washer



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

washer

Batch: 1111424

ju

38.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch M1109632

ju

39.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch 11108583

ju

40.0

NAS1611012

O-RING



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

O-RING

batch M1108673

ju

41.0

NAS1611015

O-RING



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

O-RING

batch M1107178

ju

09-04-27 ju

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 46498A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

NAS1611016

O-RING



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

O-RING

batch: ~~M 101170~~

43.0

D3492049

Plug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

PLUG ASSEMBLY

batch: B 4 63 56

44.0

D3492051

Plug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

PLUG ASSEMBLY

batch: B 3 9 7 2 3

45.0

D3492053

Plug Assembly



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

PLUG ASSEMBLY

batch: B 4 4 0 6 3

46.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign objects

2-Install Aft cap as per Dwg D3582, Detail "C"

A/R 241 Sika Flex Batch: M 111087

Exp Date: 10/12/0

3-Install Wearplates as per Dwg D3582,

Note: Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582

*****Do not install bolts where indicated on Dwg(Note #6)*****

A/R 241 Sika Flex Batch: M 111087

Exp Date: 10/12/0

4-assemble o'ring as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M 101223

911 09-04-22 (X)

W/O:		WORK ORDER CHANGES					
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Job Number: 46498A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

D3582 u

Description :

5- Wing Walk as per Dwg D3043 and QSI 005 4.4

M111013 09-04-28 (2) DTC

47.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/28 (2)

48.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D117-762-041

Location:

PPP Rev:

PPP 46498

09/04/28 (1)

49.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/28 (1)

Job Completion



MF 09-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/04/17	1	Permanant change				Le	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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	1							

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PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

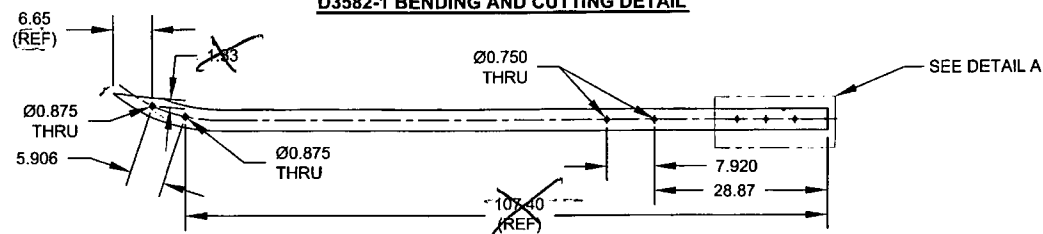
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

GENERAL NOTES:

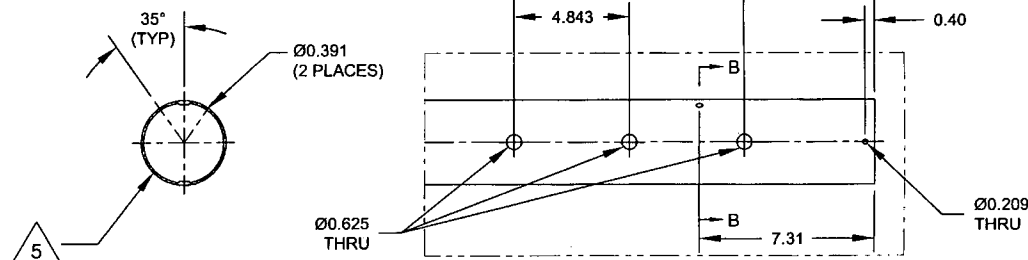
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004.
- INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.297 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- FINISH:
 - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
 - POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 - ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4



D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B
SCALE 1:5

DETAIL A
SCALE 1:5

RELEASED
07-11-22

A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	24	DART AEROSPACE USA, INC	
DRAWN	24	PORT HADLOCK, WA	
CHECKED	24	DRAWING NO.	REV. A
MFG. APPR.	24	D3582	SHEET 1 OF 2
APPROVED	24	TITLE	SCALE
DE APPR.	24	BK 117 SKIDTUBE ASSEMBLY	1:20
DATE	07.06.08	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

NO WORK ORDER
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

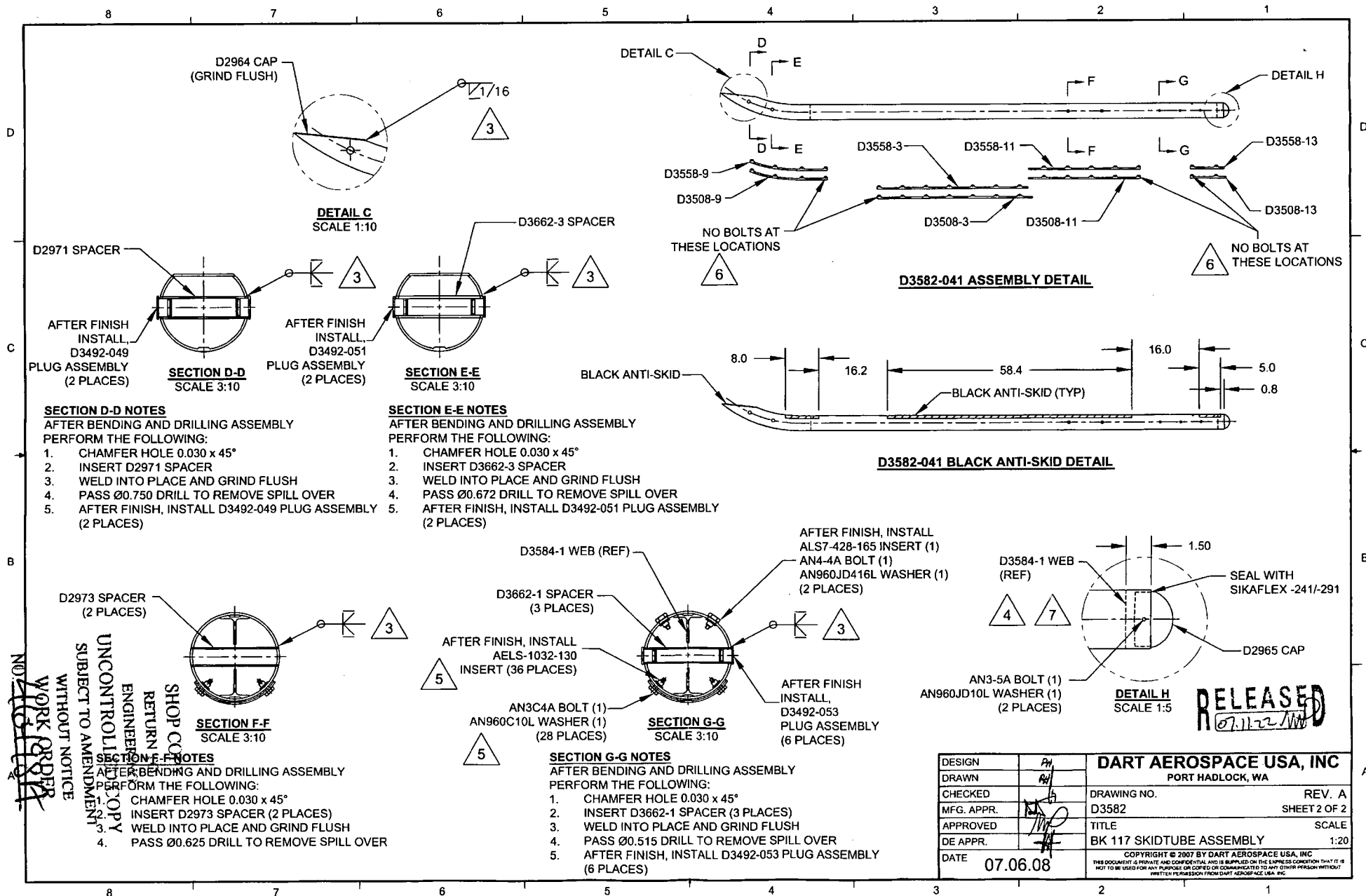
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NOTE: Date & initial all entries

NO. 169

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 40335A
Part number: D117 762 041
Description: BK 117 skid
Welding Process: Tig~~M~~ Mig~~I~~ ☐
Base materiel: Aluminium
Current: AC~~I~~ DC~~I~~ ☒

TEST REQUIREMENTS AND RESULTS

Visual: pass~~I~~ ☒ fail~~I~~ ☐
Penetration: pass~~I~~ ☒ fail~~I~~ ☐

UNACCEPTABLE

Cracks: pass~~I~~ ☒ fail~~I~~ ☐
Undercut: pass~~I~~ ☒ fail~~I~~ ☐
Pin holes: pass~~I~~ ☒ fail~~I~~ ☐
Overlap (cold lap): pass~~I~~ ☒ fail~~I~~ ☐
Porosity (surface): pass~~I~~ ☒ fail~~I~~ ☐
Coloration: pass~~I~~ ☒ fail~~I~~ ☐

Qualifier P. J. D. D. D. Date of Test Coupon 08-08-21
Welder Barclay Elliot Date of Test Coupon 08-08-21

The above named individual is qualified in accordance with AWS D17.1.2001 to weld